

Work Order ID 127248

127248

Page 1

Monday, December 15, 2014 3:34:18 PM

Item ID: D4711-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Expandable Pin Assembly
 Start Date: 12/15/2014 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/19/2014 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 14-12-15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4711	C								

100 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 26808
 Possible supplier: Mc Master Carr
 Supplier P/N: 97787A661
 Material release note is required

0.00

CL 14/12/16 12

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

12x SP14/12-22

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

(12)

DAS
38
9-89

JAN 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St 124</u>	0.00							
130									
Packaging	Memo	0.00				(12x)	DAS 46		JAN 07 2015
Packaging							0-22		
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 15-01-08

15-1-7

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 1

Required Qty: 12.00

12x SP 14-12-22.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

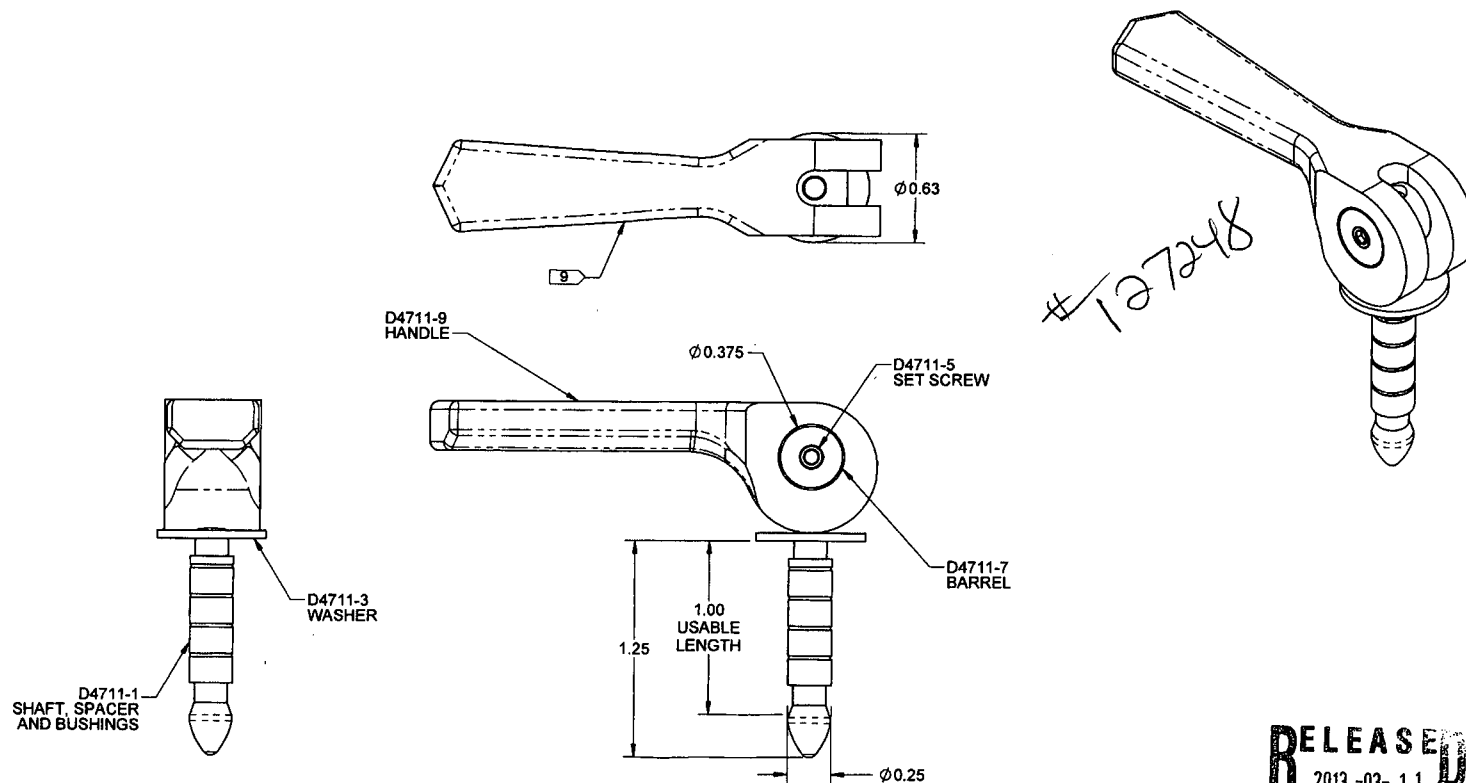
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SPECIFICATION CONTROL DRAWING



D4711-043 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5643
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A661
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	21	D4711	SHEET 2 OF 2
APPROVED	12	TITLE	SCALE
DE APPR.	12	ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-03-11

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26808

Purchase Order Date 12/16/2014

PO Print Date 12/16/2014

Page Number 4 of 5

From :
MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 330 995 5500

Ship To Contact
Ship To Phone
Ship Via: Purolator ground ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency USD
FOB FCA - (Free Carrier)

10	97787A661	Expandable Pin	12/18/2014	12.00 ✓	\$114.68	\$1,376.10
			Yes	Each		
			12/18/2014			
	AS PER DWG D4711 REV. C B127248					

Line Total: \$1,376.10

11	98470A133	Pin, Quick Release	12/18/2014	16.00	\$3.01	\$48.10
			Yes	Each		
			12/18/2014			
	AS PER DWG D4811 REV. A B127262					

Line Total: \$48.10

12	71401-45	PROCUREMENT QUALITY CLAUSES	12/18/2014	1.00	\$0.00	\$0.00
			No			
			12/18/2014			
	PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A025 CERTIFICATE OF CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS					

Note:

12/16/2014



Packing I

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO26808

Page

Order Placed By
Chantal Lavoie

12/16

McMaster-Carr Number
4966730-02

Line	Product	Ordered	Shipped
1	1761K176 Galvanized Steel 45 Degree Wye, 5 Trade Size for, Quick-Assembly Duct Your Part Number: 71400-20	2 Each	2
2	1761K203 Galvanized Steel Reducer, 5 to 4 Trade Size for, Quick-Assembly Duct Your Part Number: 71400-20	1 Each	1
3	1761K67 Aluminum Blast Gate, 5 Trade Size for, Quick-Assembly Duct Your Part Number: 71400-20	1 Each	1
4	1761K66 Aluminum Blast Gate, 4 Trade Size for, Quick-Assembly Duct	1 Each	1
5	1761K43 Galvanized Steel 90 Degree Elbow, 5 Trade Size for, Quick-Assembly Duct	1 Each	1
6	1761K435 Galvanized Steel 45 Degree Elbow, 5 Trade Size for, Quick-Assembly Duct	1 Each	1
8	1761K62 Steel Duct-to-Duct Hose Adapter, 4 Trade Size for, Quick-Assembly Duct	1 Each	1
9	1761K63 Steel Duct-to-Duct Hose Adapter, 5 Trade Size for, Quick-Assembly Duct	1 Each	1
10	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length	12 Each	12 ✓
11	98470A133 18-8 Stainless Steel Shoulder Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length	16 Each	16 ✓

SP14-12-22

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 19159774
 Purchase Order: PO26808
 Release:
 McMaster-Carr Number: 4966730-02

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
6	1761K435 Galvanized Steel 45 Degree Elbow, 5 Trade Size for, Quick-Assembly Duct Country of Origin: United States Schedule B #: 732690 ECCN #: EAR99 NLR	1 EA	\$50.84	\$50.84
8	1761K62 Steel Duct-to-Duct Hose Adapter, 4 Trade Size for, Quick-Assembly Duct Country of Origin: United States Schedule B #: 732690 ECCN #: EAR99 NLR	1 EA	\$22.63	\$22.63
9	1761K63 Steel Duct-to-Duct Hose Adapter, 5 Trade Size for, Quick-Assembly Duct Country of Origin: United States Schedule B #: 732690 ECCN #: EAR99 NLR	1 EA	\$25.19	\$25.19
10	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length Country of Origin: United States Schedule B #: 731829 ECCN #: 9A991 NLR	12 EA	\$114.68	\$1,376.16
11	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length Country of Origin: United States Schedule B #: 731829 ECCN #: EAR99 NLR	16 EA	\$3.01	\$48.16
	NOTE Tracking number(s) for this shipment: MFA003989196			

SP14-12-22